April-30-13 2:39		1066		*101	1066*						Page 1	
Revision ID: Item Name:	D3208-3 Pedal Mount 4/30/13 4/30/13	Angle Start Qty: 6.00 Req'd Qty: 6.00	*6 *6		*N900 Cust Item I Customer:		100)* s	etup Sta	IV	S1* S2*	
Reference:			()					_	St.		•	
		an: MCJ		SPC (Y/N):		ate:		R	tun Sta Sto	1/7	R1* R2*	
Sequence ID/ Work Center ID	······································	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Re	vision Nbr						*				
D3208	C											
*100 *100* Waterjet		FLOW WATER JET Memo		0.00				8	ی		<u>Ae</u> 13.06	70
FLOW CNC Waterjet	t		et.					_			13.56	30
		2-Deburr if	•							*		
*110 * QC Quality Control		QC2- Inspect parts off m	achine FAI/FAIB	0.00		i		8	0		13.06	・ るこ

NCR:	Yes	/	No	

DQA:

Date: __

NCR: Y	es / No				WORK ORDER NON-O	CONFOR	MANCE / UP	DATE			
									QA Closed:	Date:	
Work Orde	ř:	-			DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
			. ,		Rework]	Skid-tube	Crosstube]	Water Jet	Engineering
Part N	0				Scrap] [Machining	Small Fab	4	d. Eng. Coor.	Quality
					Use-as-is	Ther	moforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	0				Work Order Update]	Large Fab	Composite	j	Supplier] []
Root		1		Descri	ption of work order update	Initial	Ι Δ.	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng		cription	Date	Verification	QC Inspector
Doc/Data	Date	эсер	Qty		or Non-comormance	Ciliei Liig	Desc	прион	Date	vermeation	QC IIISPECTOI
quip/Tooling											
Operator						1					
Material						1					
etup											
Other							Ì				
rocess						1					
Supplier											
raining		1									
Jnapproved						1					
					F	AULT CAT	EGORY				
Landir	g Gear				General				_		
[Bending				Bend	Grain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to (o/s	BOM/Route	Hardw	are		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspec	tion Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped			Burrs	Instru	tions Incomplete/	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	Maint	enance		Part Moved		
	Heat Trea	at			Countersink	Mislat	eled		Positioned V	Vrong	_
	Inspectio	n Strip in	Tube		Cut Too Short	Misrea	nd		Power Loss/	Surge	Other
	Ripples in	n Bend			Drill Holes	Offset					
	Torque V	Vaves in E	Extrusio	n [Drawing	Out of	Calibration				
	Turning S	Sequence			Finish	Out of	Sequence				
	Wave/Tw	vist in Tul	be		Folio	Outsic	e Dimensions				

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Work Orde April-30-13 2:3		1066		*101	066*						Page 2	
Item ID: Revision ID:	D3208-3			Accept	*N900	040	100)* : s	etup Star Stop	1 7	S1*	
Item Name: Start Date: Required Date: Reference:	Pedal Mount 4/30/13 4/30/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:				"N	S2*	
Approvals:		an:	Date:	Tooling: SPC (Y/N):		ate:		R	un Star Stop		R1* R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
*120 *120* QC Quality Control		QC8- Inspect parts - seco	ond check	0.00				E) BO	103	OAS 09 9-89	;)
130 *130* Brake NC Brake NC		Bend as per dwg NC BRAKE Memo		0.00				_8_			Sh 17	67/0
140 *1 4 0* QC	·	QC5- Inspect part comp	leteness to step on W/O	0.00 AS 16 0.00 9-5 / (2	10/12			(48)		agi <u>o appoints</u> as a second		· • • • • • • • • • • • • • • • • • • •

140 *140* QC Quality Control

												DQA:	Da	ate:	
NCR: Y	es/	/ No				WORK ORDER NON-O	CON	IFORI	MANCE / UPI	DATE		•			
												QA Closed:	Da	ate:	
Work Orde	er:					DISPOSITION				AGAINST D	EF	PARTMENT	PROCESS		
Part N	•				· · · · · · · · · · · · · · · · · · ·	Rework Scrap			Skid-tube Machining	Crosstube Small Fab			Water Jet		Engineering Quality
NCR N	lo					Use-as-is Work Order Update]	Thern	noforming Large Fab	Finishing Composite	_	Rec/Stor	e/Packaging Supplier	-	Other
Root					Descri	ption of work order update	Ir	nitial	Act	tion	٦	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Chi	ief Eng	Desci	ription		Date	Verification	n	QC Inspector
Doc/Data															
Equip/Tooling												·			
Operator	\Box														
Material							-								
Setup											1				
Other							1								
Process														1	
Supplier															
Training															
Unapproved															
						F.	AUL	T CATE	GORY	•					
Landi	ng G	iear				General				_					_
		Bending				Bend		Grain				Ovalized			Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re			Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged	П	Inspect	on Incomplete			Part Incorrec	t		Weld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

Wrong Stock Pulled

Other

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Work Ord		01066		*101	066 *				Page 3
Item ID: Revision ID:	D3208-3			Accept	*N900	04010	10 *	Setup Start	*NS1*
Item Name:	Pedal Mount	Angle		•				Stop	*NS2*
Start Date: Required Date Reference:	4/30/13 : 4/30/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:			
Approvals:	Process P	lan:	Date:	Tooling:	Da	ate:		Run Start	*NR1*
Approvais						ate:		Stop	*NR2*
Sequence ID/ Work Center I	 D	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Plar Cod		Reject Qty	Reject Insp. Number Stamp
150		Chemical Conversion Co	oat per QSI005 4.1	0.00					
150 HandFinish		Мето		0.00			8	16	13-74
Hand Finishing									
160		QC7-Inspect Chemical (Conversion Coat	0.00			0		
160 QC Quality Control		Мето		0.00 RJ 8	,				
is ·									
170		Identify as per dwg & St	tock Location: ST202	0.00					1.1
170 Packaging		Memo		0.00			-X-X	/ /	1.13-07-8

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DQA: _____ Date: ____

NCR: Y	es / No				WORK ORDER NON-C	ONFC	JKIV	IANCE / UPI	DAIE	QA Closed:	Date	9 :
Work Orde	r:				DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
Part N					Rework Scrap		N	Skid-tube Machining	Crosstube Small Fab	- -}	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	o				Use-as-is Work Order Update	Th		oforming Large Fab	Finishing Composite	Rec/Sto	e/Packaging Supplier	Other
Root				Descri	ption of work order update	Initia	al	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E	Eng	Descr	ription	Date	Verification	QC Inspector
Ooc/Data												
quip/Tooling						1						
Operator												
Material												
etup							1					
Other			ļ [
Process						1	ļ					
Supplier		ı										
raining						-						
Jnapproved												
					F	AULT CA	ATEG	ORY				
Landin	g Gear				General				_			
	Bending				Bend	Gra	ain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to (o/s	BOM/Route	Har	dwar	e		Over/Under	tolerance	Temperature/Cure
[Cracks				Broken/Damaged	Insp	pectio	on Incomplete		Part Incorre	ct [Weld
[Crushed/	Crimped			Burrs	Inst	tructi	ons Incomplete/l	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	Ma	inte	nance		Part Moved	_	
	Heat Trea	at		Г	Countersink	Mis	slabel	ed	Γ	Positioned V	Vrong	
Ī	Inspectio	n Strip in	Tube		Cut Too Short	Mis	read			Power Loss/	Surge	Other
	Ripples in				Drill Holes	Offs	set		<u> </u>		_	-
Ī	Torque V	Vaves in E	Extrusion	, F	Drawing	Out	t of C	alibration				
Ţ	Turning S				Finish	Out	t of S	equence				
ľ	Wave/Tv				Folio	Пош	tside	Dimensions				

Work Orde		101066		*101	1066*							Page 4
Revision ID:	D3208-3 Pedal Mou	int Angle		Accept	*N900	040	100)*	Setup	Start Stop	, 4	S1* S2*
Start Date: Required Date: Reference:	4/30/13 4/30/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:						
Approvals:	Process QC:	Plan:	Date:			ite:		1	Run	Start Stop		R1* R2*
Sequence ID/ Work Center II 180 *180*)	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
QC Quality Control		Memo		0.00					<u> </u>	+!/		Y Y

2

13-7-9

NCR:	Yes	1	No	

Date: _

NCR: Ye	es / No				WORK ORDER NON-C	CONFORI	MANCE / UP	DATE			
				·		<u></u>			QA Closed:	Date	
Work Order	ŕ:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No					Rework Scrap	4 1	Skid-tube Machining	Crosstube Small Fab	-	Water Jet d. Eng. Coor.	Engineering Quality
NCR No	o				Use-as-is Work Order Update	Inerr	noforming Large Fab	Finishing Composite	Rec/Stoi	re/Packaging Supplier	Other
Root		· ·		Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data					-			-			
quip/Tooling											
Operator		Ì									
Material	4						1				
Setup	_						;				
Other	_										
Process	_										
Supplier	_										
Training	_					1					
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Landin	- Coor					AULT CATE	GORY				
Landin,	Bending			_	General Bend	Grain		_	70	_	ا ، ا
-	Centre No	nt Conso	ntric to (\	BOM/Route	Hardwa		<u> </u>	Ovalized	A-1	Pressure/Forced
}	Cracks	or conce	intric to t),3 -	Broken/Damaged		ire ion Incomplete	⊢	Over/Under	 	Temperature/Cure Weld
-	Crushed/	Crimped		·	Burrs		tions Incomplete/	Uncloar	Part Lost/Mi	·]
·	Cuffs	Crimped		· -	Contamination	Mainte		- Inclear	Part Moved	22111B	Wrong Stock Pulled
<u> </u>	Heat Trea	nt		-	Countersink	Mislabe		-	Positioned V	Irong	
<u></u>	Inspection		Tube		Cut Too Short	Misread		 	Power Loss/		Other
-	Ripples in			·	Drill Holes	Offset	•	<u>L</u>	J. OWEL 1035/.	Juige	Portier
F	Torque W		Extrusion	,	Drawing	⊢	Calibration				
<u> </u>	Turning S				Finish	⊢ –	Sequence				
	Wave/Tw				Folio	\vdash	Dimensions				

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DART AEROSPACE LTD	Work Order:	101066
Description: Pedal Mount Angle	Part Number:	D3208-3
Inspection Dwg: D3208 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

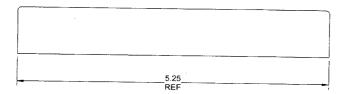
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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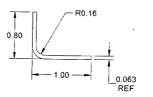
Measured by:	Ae	Audited by:	DAS	Preliminary	Approval:	
Date:	13.06.30	Date:	13-07-02° 88		Date:	

Rev	Date	Change	Revised by	Approved
Α.	06.10.27	New Issue	. KJ/JLM	
В	12.06.21	Dwg Rev updated	KJ , A	2/
С	12.07.31	0.063 dimension revised	KJ ØK	(will
	12.07.51	0.003 differision revised	$\frac{1}{\sqrt{7}}$	Jan Jan

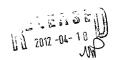
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> N. 101066 MCJ 13-05-01





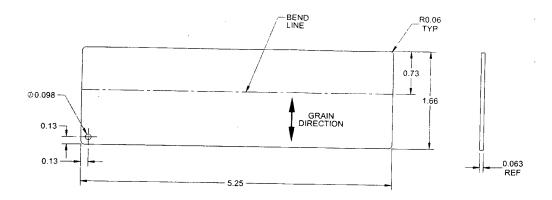
D3208-3 PEDAL MOUNT ANGLE



NOTES:	
1) MATERIAL	: MAKE FROM D3208-3F FLAT PATTERN
FINISH: CI	HEMICAL CONVERSION COAT PER DART OSI 005 4 1
3) FOLERAN	CES: PER DART QSI 018 UNLESS OTHERWISE NOTE
4) UNITS: INC	CHES UNLESS OTHERWISE NOTED
5) BREAK SH	IARP EDGES: 0.005 TO 0.010 MAX
iDENTIFIC	ATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: () 05 the

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	\$	DRAWING NO.	REV. C
MFG. APPR.	77	D3208	SHEET 3 OF 9
APPROVED	Alt	TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE 12.04.12		COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS STRIKE AND CONFIDENTIAL AND IS LIPPLED ON THE LIPPLES CONDITION THAT IT IS NOT TO BE USED FOR ANY AMPOSED OR COPERIOR COMPANIED TO ANY FORE PERSON WITHOUT	

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D3208-3F PEDAL MOUNT ANGLE FLAT PATTERN

1 2012 -04- 18 K

NOTES: 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF DART SPEC M2024T3S.063

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.05 lbs

-D

DESIGN	RF	DART AEROSPACE LTD		
DRAWN RF		HAWKESBURY, ONTARIO, CANADA		
CHECKED	8	DRAWING NO.	REV C	
MFG. APPR.	- N	D3208	SHEET 4 OF 9	
APPROVED	4	TITLE	SCALE	
DE APPR.	-#	DOUBLER	NTS	
DATE 12.04.12		COPYRIGHT © 2004 BY DART AEROSPACE LTD INS DOQUENT IS PRIVATE AND CONFERENTIAL AND IS SUPPLED ON THE EURIES'S CONSTITON THAT IT IS NOT 10 OR USED FOR ANY PROPECT OR ODE OR COMMANDATE TO ANY DARR PRESON WITHOUT		

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